

Date: Thursday, 5/4/2006 11:12:39 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING BRACKET
Job Number	: 26940		
Estimate Number	: 11796		
P.O. Number	: N/A	Part Number	: D2523
This Issue	: 5/4/2006 S.O. No. : N/A	Drawing Number	: D2523 REV A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A2
Previous Run	: N/A	Material	: N/A
Written By	: <u>SRE (Comment Below)</u>	Due Date	: 5/20/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>KJ 06.05.05</u>		
Comment	: Est. C 01.04.16 Re format, added DT8560 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X12000	6061-T6 Bar 1.0" x 12.0"
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Comment: Qty.: 1.9031 f(s)/Unit Total: 19.0313 f(s)
 6061-T6 Bar 1.0" x 12.0"
 Material: 6061-T6 (QQ-A-200/8) 1.00" thick
 Note: 2 per blank. Batch M14389

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 21.75" x 12.00"

JL / J.G 06/05/15 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2523

JF / SD / J.L / J.G 06/05/15 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF / SD / J.G / 06/05/15 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/05/18 10

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr
 Drill holes as per dwg D2523 using DT8560

FF 06.05.18 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 06/05/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:12:39 AM
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Drawing Name: MOUNTING BRACKET

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



J 0605-23

(10)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HM 06/05/24

(10)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-25

(10)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06/05/26 10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AP 06/05/26

(10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST182*

AP 06/05/26

(10)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/27

(10)

Job Completion:



U 06-05-29



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26940
Description: Mounting Bracket		Part Number:	D2523
Inspection Dwg: D2523	Rev: A2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005/-0.000	0.259	✓			
1.076	+/-0.010	1.074	✓			
1.985	+/-0.010	1.982	✓			
Ø0.257	+0.005/-0.001	0.259	✓			
9.372	+/-0.010	9.371	✓			
1.035	+/-0.010	1.035	✓			
Ø0.191	+0.005/-0.000	0.191	✓			
7.546	+/-0.010	7.543	✓			
2.776	+/-0.010	2.773	✓			
2.776	+/-0.010	2.772	✓			
0.875	+/-0.010	0.876	✓			
R0.125	+/-0.010					
1.00	+/-0.030	1.016	✓			
R0.125	+/-0.010	0.125	✓			
0.750	+/-0.010	0.747	✓			
0.250	+/-0.010	0.251	✓			
R0.250	+/-0.010	0.250	✓			
0.125	+/-0.010	0.141	✓		see attached	E-mail J.G.
R0.125	+/-0.010	0.125	✓			
R0.063	+/-0.010	0.063	✓			

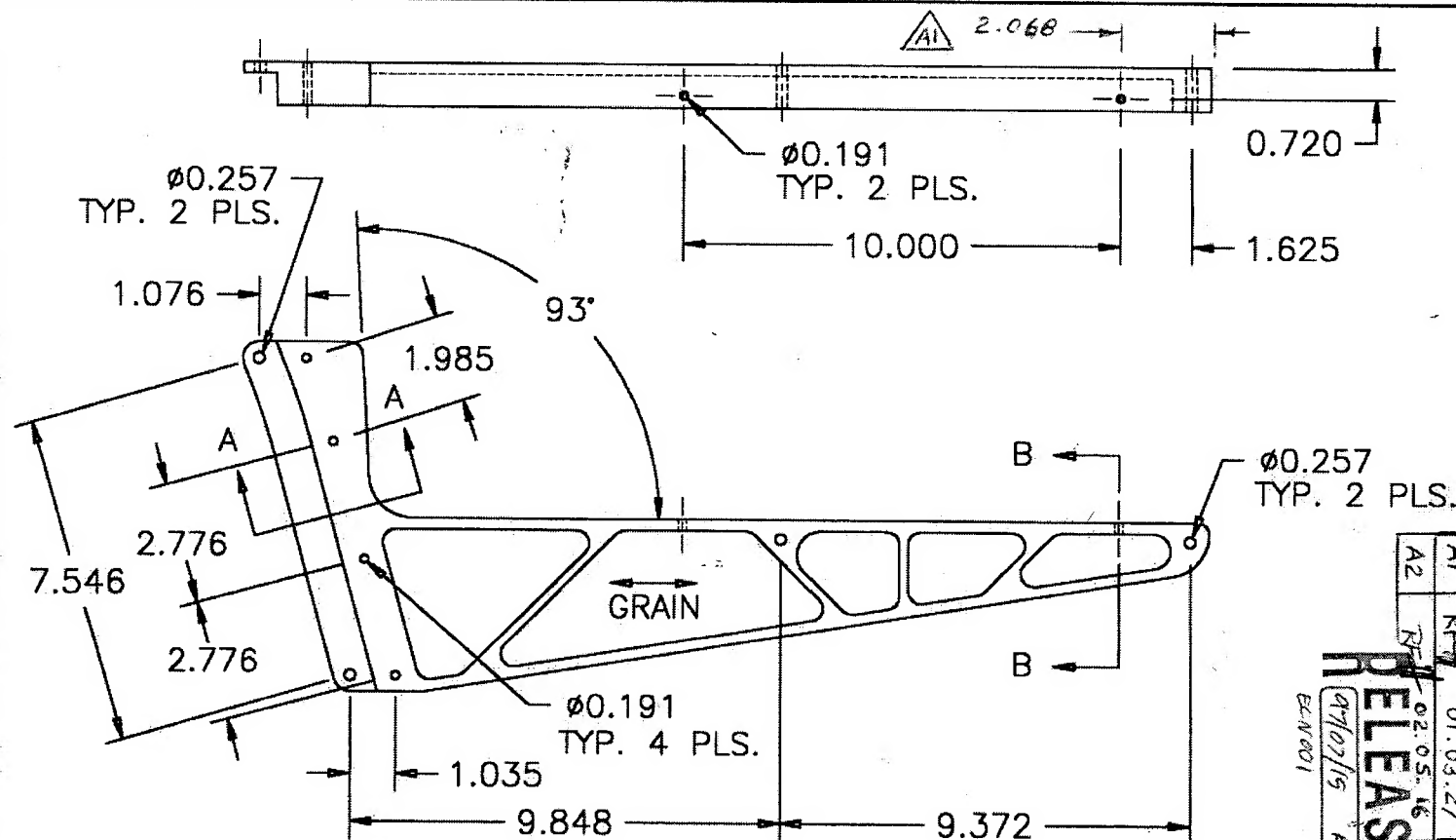
Measured by: J.G.	Audited by:	Prototype Approval:	N/A
Date: 06/05/15	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. A
CHECKED B.D.	APPROVED K.E.	DRAWING NO. D2523	SHEET 1 OF 1
DATE 95.12.20	TITLE MOUNTING BRACKET	SCALE 1:4	
A	95.12.20	NEW ISSUE	
A1	REF 01.03.27	ADDED DIMENSION	
A2	REF 02.05.16	R0.125 WAS R0.250	

RELEASED
07/07/15
K.E.
Eca-001



SECTION A-A
SCALE 1:2

SECTION B-B
SCALE 1:2

MATERIAL: 6061-T6 QQ-A-200/8 1.00 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26910

David,

The material used for this piece is 1.016". The nominal dimension is 1.000".

The deviations are noted on the drawing

① pocket is 0.125 ± 0.016 (0.141") deep instead of ~~0.125~~ 0.125"

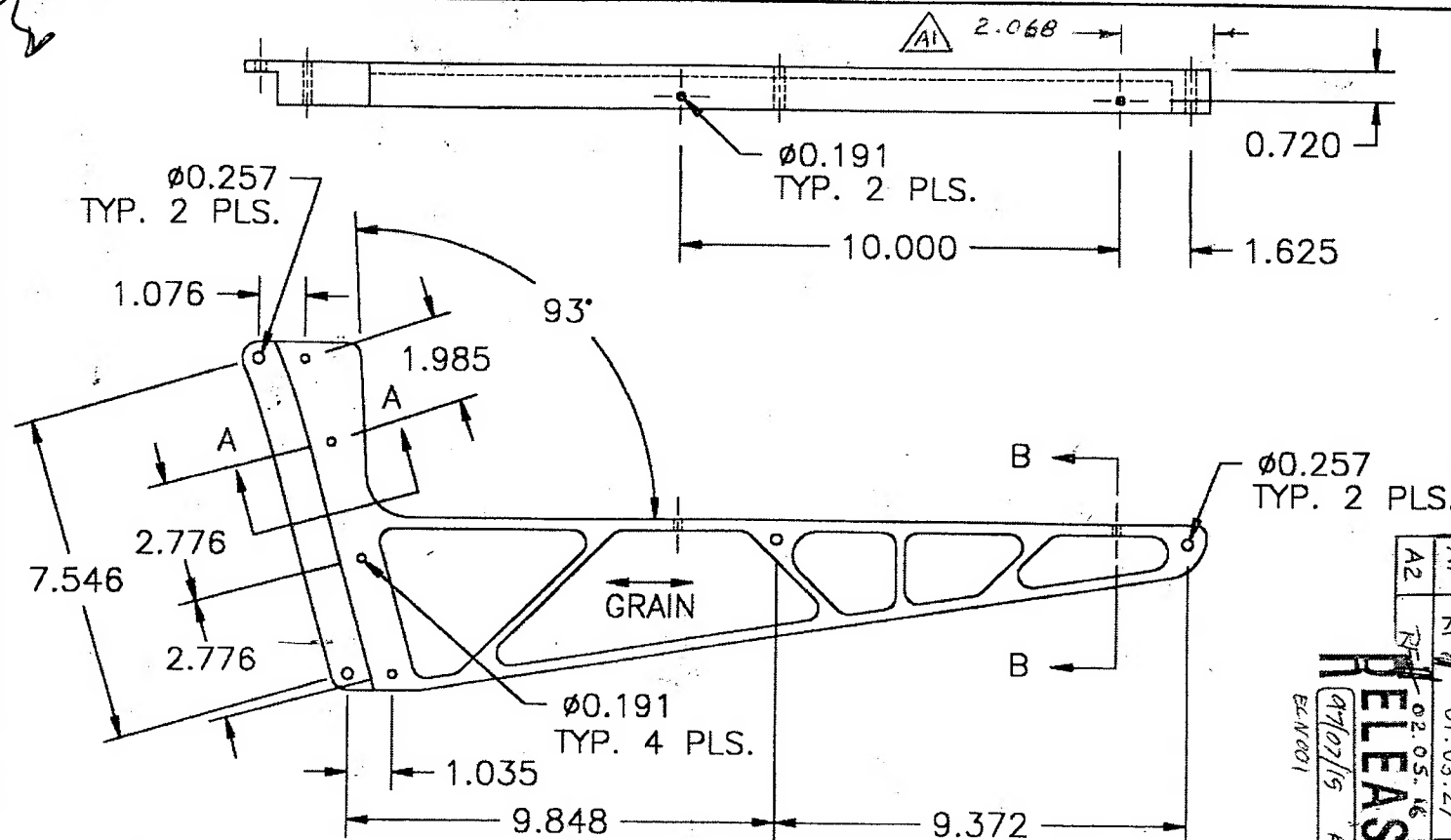
② part is too thick

Is this deviation acceptable? Yes ~~off~~ 0.05.15

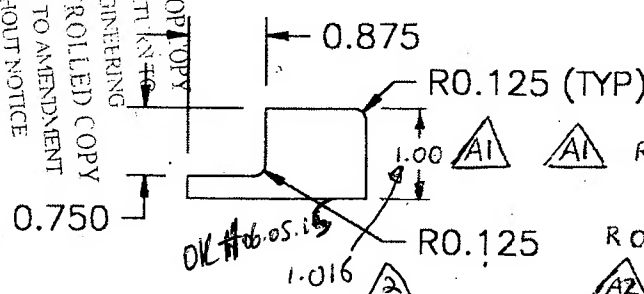


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>KE</i>	DRAWING NO. D2523
DATE 95.12.20	TITLE MOUNTING BRACKET	REV. A SHEET 1 OF 1
	NEW ISSUE	SCALE 1:4
A	95.12.20	ADDED DIMENSION
A1	01.03.27	
A2	02.05.16	

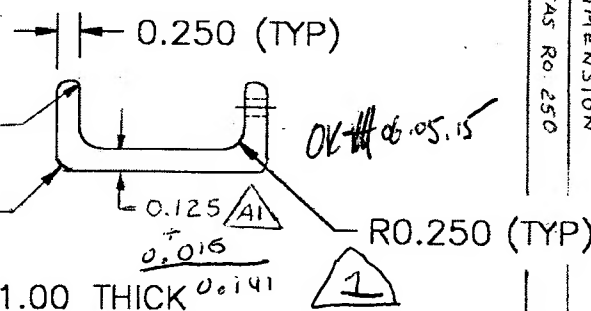
RELEASED
9/07/15 KE
ELN001



SECTION A-A
SCALE 1:2



SECTION B-B
SCALE 1:2



MATERIAL: 6061-T6 QQ-A-200/8 1.00 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

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